In the Specification

Please amend the specification as follows.

Please replace the paragraph on page 9, beginning on line 10, with the following replacement paragraph:

The previously circularly cylindrical annual wall 266 of the head part 210a tapers at the end region 264 remote from the shaft part 210b into a rounded, bullet-like design or cigar shape 268, with the end 270 not being closed, but open, and defining an aperture 272 which is substantially smaller than the diameter of the cylinder bore 220. The end region 264 of the functional element 210 is, so to say, spherically rounded with a flat, open end face 270. As can be seen from Fig. 1, the hollow end region 274 of the element between the end face 270 and the aperture 272 is formed in the manner of a truncated cone, and indeed such that the end region 264 of the head part 210a has an annular, inclined surface 274 at the inside with an included cone angle of approximately 45°. The wall thickness of the hollow region of the head part 210a is at least substantially the same over the total length of this region. The reference numeral 236 indicates the central longitudinal axis of the functional element 210 and it can be seen that the shaft part 210b and the head part 210a are axially arranged relative to one another with respect to this central longitudinal axis [~~276~~] 236. Although the head part 210a of the functional element is circular in cross-section in this embodiment, it is feasible to select a cross-sectional shape deviating from the circular shape, for example a polygonal shape or a shape with longitudinal grooves or longitudinal ribs, in particular when an even better security against rotation is required in the installed state.

Please replace the paragraph on page 12, beginning at line 18, with the following replacement paragraph:

In the closed state of the die, the radially inwardly directed partly circular cylindrical surfaces 217b of the shaped parts 216 contact the cylindrical outer surface of the upper part

234a of the abutment element. The shaped parts 216 are furthermore each provided in the region of their upper ends with a bead-like or nose-like projection [~~220~~] 219, which faces the longitudinal axis 222 and with which sheet metal material of the sheet metal part 212 can be pressed in a manner to be described below into an undercut of the functional element 210 which is formed. In this embodiment, the nose-like projections [~~220~~] 219 form the lateral boundary of the reforming space 230. Radially extending grooves 231 are worked into the end face 232 of the ~~shaped parts 216~~ shaped part 234a so that noses 233 lie therebetween, with the bases 235 of the grooves 231, which are roughly semi-circular in shape in cross-section, being inclined with respect to the longitudinal axis 222 of the die, as can be seen from Fig. 3.~~ and above all from Fig. 5A~~. The grooves 231 are generally rounded and, like the noses 233 lying therebetween, serve to provide security against rotation. A total of eight grooves 231 and eight noses 233 are present in this example - a different number would also be possible.

Please replace the paragraph on page 15, beginning on line 6, with the following replacement paragraph:

The hold down member 316 is also biased in the direction towards the sheet metal part 212, and indeed by springs [~~218~~] 318 which - like the spring 312 - are here indicated schematically as compression coil springs, even though other spring types can also be used which are very well-known in tool making.

Please replace the paragraph on page 15, beginning on line 12, with the following replacement paragraph:

In this example, three springs [~~316~~] 318 are likewise arranged at equal angular intervals around the central longitudinal axis 222 so that the hold down member 316 is pressed evenly downwards under the force of these springs.

Please replace the paragraph on page 16, beginning on line 1, with the following replacement paragraph:

The plunger 304 has further pressed the end 270 of the functional element 210 and the sheet metal material into the reforming space 230 and thus moved the abutment element 234 slightly downwardly against the force of the spring 228 so that the reforming space 230 has become deeper. In doing so a recess 212a is formed there in the sheet metal part 212. The annular shoulder 280 moves away from the lower side 278 of the shaped parts 216 and the annular shoulder 283 likewise moves away from the annular shoulder [~~282~~] 285. The force which is exerted on the sheet metal part 212 via the setting head and the functional element does not result in a movement of the shaped parts 216 as these always remain in the same position up to the completion of the attachment of the functional element to the sheet metal part 212. As the press continues to close, the inner plunger 304 and the outer plunger 303 move lower with respect to the hold down member 316 and in so doing press the abutment element 234 into its lowest position in accordance with Fig. SC, with the recess 212a in the sheet metal part becoming deeper.

Please replace the paragraph on page 16, beginning on line 18, with the following replacement paragraph:

As the closing movement of the press continues, the recess 212a of the sheet metal part 212 becomes wider at its lower end without any axial escape movement of the shaped parts 216 taking place, until finally the sheet metal part 212 is clamped between the ~~arched~~ dome like projection 234c of the abutment element 234 and the end 270 of the head part 210a of the functional element 210, with the ~~arched~~ dome like projection 234c generating a dent 212b directed slightly upwardly in the sheet metal part so that this is slightly pressed into the aperture 270 at the end of the functional element.

Please replace the paragraph on page 16, beginning on line 27, with the following replacement paragraph:

In a further stage of the closing movement of the press, the force exerted on the head part 210a of the functional element 210 results in a deformation of its lower end so that the form is produced which is shown in Fig. 5D. It can be seen that the sheet metal part 212 has laid itself around the rounded edges of the nose-like projections [~~220~~] 219, that the end 270 of the head part 210a of the functional element has partly laid the sheet metal part around the ~~arched~~ dome like projection 234c at 212b and that during these deformations the end of the head part 210a is itself deformed so that the functional element is expanded slightly radially outwardly in the region of its lower end, while the region around the previous end face 270 has been deformed axially inwardly and the aperture [~~270~~] 272 is now located in a concave region 210c of the head part 210a.

Please replace the paragraph on page 17, beginning on line 16, with the following replacement paragraph:

The lower end of the outer plunger 303 of the setting head 300 of the die 214 has further approached the sheet metal part 212. It can be seen in Figure 5E that the cylindrical wall region of the head part 210 has now been compressed such that a bulge 320 projecting radially outwardly has formed due to a folding of the cylindrical wall region. It can also be seen that a further pronounced annular fold or annular bulge is present at the point 322 where the axially directed wall of the head part 210a merges into the radially inwardly directed region 212b which is formed from the former end region 264 of the head part 210a.

Please replace the paragraph on page 17, beginning on line 26, with the following replacement paragraph:

On reaching the state in accordance with Figure 5F, the compression of the head part 210a of the functional element 210 is now so large that the annular fold at the point 322 has

now moved beneath the radially inwardly directed projections [~~220~~] 219 of the shaped parts within the deformation space 230 and the sheet metal part 212 has bent correspondingly around these projections. Furthermore, the lower end of the head part 210a has pressed the sheet metal part against the annular shoulder 234d of the abutment element so that the deformation space 230 is almost completely filled. The annular fold 320 is even more pronounced in comparison with Fig. 5E and the annular fold 326 of the sheet metal part 212 around the projections [~~220~~] 219 is already trapped in the radially inwardly directed annular bulge 324 being formed between the annular fold 320 and the annular fold 322.

Please replace the paragraph on page 21, beginning on line 16, with the following replacement paragraph:

Fig. 6A now shows a possible plunger arrangement 400 in detail which can be used advantageously in place of the plunger arrangement 303, 304 in accordance with Fig. 5.

Please replace the paragraph on page 21, beginning on line 20, with the following replacement paragraph:

The outer plunger 403 is provided with ~~an inner bore~~ a plunger passage 402 which is arranged coaxially to the longitudinal axis 405 and displaceably receives the inner plunger 404. A supply passage 406 is shown on the right-hand side of the sectional drawing in accordance with Figure 6A through which functional elements 210 are led from a feed device (not shown) into the plunger passage formed by the bore 402. One notes that the longitudinal axes 236 of the individual functional elements are parallel to the longitudinal axis 405 of the plunger passage 402 and that the individual functional elements are arranged in rows contacting one another. However, due to the dimensions of the plunger passage 402, only one functional element 210 at a time can be located in the plunger passage 402.

Please replace the paragraph on page 22, beginning on line 11, with the following replacement paragraph:

The outer plunger 403 is made in a plurality of parts in this embodiment and comprises a lower annular part 412 which is fastened to an upper part 414 by screws (not shown). The lower annular part 412 has a central aperture 416 with an annular wall 418 of circularly cylindrical shape which merges into a conical region 420. Both the ~~circular cylindrical region 419~~ annular wall 418 and the conical region 420 are arranged concentrically to the longitudinal axis 405. The upper part 414 of the outer plunger 403 is provided with a conical recess 422 which merges into the plunger passage 402 via an annular shoulder 424. The conical region 422 and the annular shoulder 424 are also arranged concentrically to the longitudinal axis 405 of the plunger arrangement.

Please replace the paragraph on page 25, beginning on line 17, with the following replacement paragraph:

Although not shown in Figure 6A, the arrangement is made such that the inner plunger 404 cannot move any further downwards than as shown in Fig. 6C. This can, for example, be prevented by the upper part of the inner plunger 404 being provided with a head (not shown) which has come into contact with the outer part 403 of the plunger in its "lowest" position in accordance with Fig. 6C. The force of the press is now transferred via the inner plunger 404 to the end face 292 of the functional element 210 and via the outer plunger [~~402~~] 403 and the segments 426 to the thread 211 of the functional element. It is ensured in this way that the thread cannot be damaged as it is received in a form-locked manner inside the complementary thread parts of segments 426 so that the thread cylinder cannot be compressed. If the shaft part 2 10b of the functional element is intended to be made hollow, the cylindrical projection 452 of the inner plunger 404 can be designed accordingly and can extend via an annular shoulder (not shown) pressing onto the end of the functional element 210 into the inner bore of the shaft part so that the pressing forces can be transmitted to the functional element 210 without any damage to this element by the pressing together of the

walls of the hollow shaft part needing to be feared, as this element is supported by the extended projection of the inner plunger.

Please replace the paragraph on page 27, beginning on line 1, with the following replacement paragraph:

After the release of the functional element 210 just attached, the opening of the press further results in the outer plunger 403, which is biased downwards by the spring force, being pressed downwards, while the inner plunger 404 is drawn upwards until it reaches the starting position where the lower end face 408 of the inner plunger 404 has reached the level of the upper boundary of the passage [~~466~~] 406, whereby a new element is introduced into the plunger passage 402 by the pressure in the direction of the arrow 410. The working cycle then begins afresh with a new sheet metal part and with a new functional element 210, namely the functional element that is now located in the plunger passage 402.